

Date: Friday, 31/10/2008 10:00:43 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 43108			Part Number	: D2596	
Estimate Number	: 10346			Drawing Number	: D2596 REV D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 31/10/2008		S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SKIDTUBES	Due Date	: 10/11/2008
Previous Run	: 42337				Qty:	4
Written By	:			Um:	Each	
Checked & Approved By	<u>JUL 08-10-31</u>					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -'I' Beam Web 4"	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion <u>B 33940</u> <u>JUL 8-11-3</u>			
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr <u>JUL 8-11-3</u>			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 <u>JUL 8-11-4</u>			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP <u>S 08/11/04 (X4)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 8-11-04 (4)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/05 AF

Job Completion



MF 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASER
07.06.2018

DRAWN BY		DART AEROSPACE LTD		
DESIGN		HAWKESBURY, ONTARIO, CANADA		
DATE	APPROVED	DRAWING NO.	SHEET 1 OF 1	REV. D
07.04.17		D2596		
A	96.09.16	205 WEB		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

DETAIL A
SCALE 1:4

1.750 3.500 1.750

0.50 1.750 1.750

REFER TO DETAIL A

0.875 17.38 26.00 34.19 42.38 46.01 50.56 85.59 91.50 99.50

Ø0.63 (22 PLACES)

0.50 (REF)

32.75 (REF)
4 EQUAL SPACES
8.19 PITCH

42.38 46.01 50.56 85.59 91.50 99.50

D

D
STOP COPY

UNCONTROLLED DRAWING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

22398 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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